Work Order ID 64431

Monday, December 06, 2010 9:13:34 AM

Item ID: D4035-045 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Lid Rib Assembly, Fwd (Light)

Start Date: 12/6/2010 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 12/13/2010 **Req'd Qty:** 2.00 **Customer:**

Reference:

Approvals: **Process Plan:** RA **Date:** 12-6 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D4035	Revision Nbr: A								
100	Weld per dwg A/R Aluminum rod Batch: 112860	0.00				2			
Large Fab	**Memo**	0.00							
Large Fab	1- Cut D4035-1 as per dwg D4035 2- Drill holes as per dwg D4035 using DT9619 ~~3- remove identification marks and deburr~~ SAO 11-01-24 4- Weld bushing in rib as per dwg D4035 → RA 11.01.25								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00				2	0	BE 11/01/26	
QC	**Memo**	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 64431

Monday, December 06, 2010 9:13:34 AM

Item ID: D4035-045 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Lid Rib Assembly, Fwd (Light)

Start Date: 12/6/2010 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 12/13/2010 **Req'd Qty:** 2.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00				(2)			
QC	**Memo**	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: CA	0.00				(2)			
Packaging	**Memo**	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00					11/01/27		
QC	**Memo**	0.00							
Quality Control									

11-01-26

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Monday, December 06, 2010 9:13:38 AM

Work Order ID: 64431

Parent Item: D4035-045

Parent Item Name: Lid Rib Assembly, Fwd (Light,

Start Date: 12/6/2010 **Required Date:** 12/13/2010

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP RevA: new issue DD 10.01.25 verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2953-175		Manufactured	No			100	Each	18.0000	1	2			
Spacer										cpl 11.01.25			
				Location			**Loc Qty**		**Loc Code**				
				WA			18						
					57335		16						
					59742		2			(2)			
M6061T6TS0.750W.06 2		Purchased	No			100	f	120.9123	1.875	3.947368			
6061-T6 SQ Tube .75 x .75 x .062W										SAD 11-01-24			
				Location			**Loc Qty**		**Loc Code**				
				MAT			43.23707						
					114573		22.1055			END Bar			
					114640		21.13157			3.9474 → Scrap 0.34197			
				MAT06			77.6752			total 4.28937			
					103069		38.0526						
					104422		15.5263						
					16441		4.07						
					9671		20.0263						

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

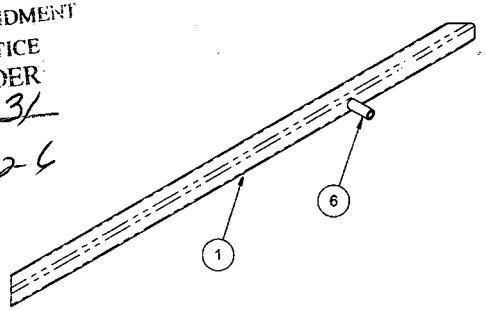
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

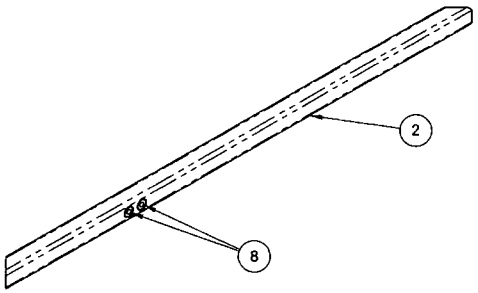
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 64431
2/10/12-6

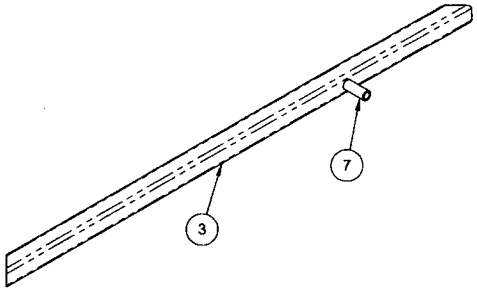
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			X		D4035-045	LID RIB ASSY, FWD (LIGHT)
				X	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7			1		D2953-175	SPACER
8		2			D4021-9	BUSHING



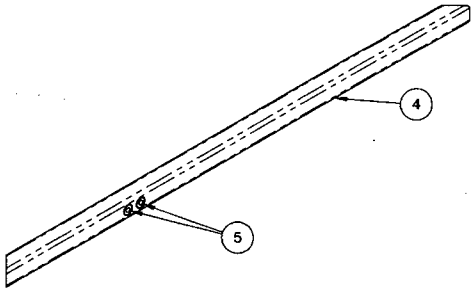
D4035-041 BASKET LID RIB ASSY, FWD



D4035-043 BASKET LID RIB ASSY, AFT



D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)



D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

RELEASED
2010 -03- 12

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	JPH	10.03.04

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	JPH	
CHECKED		DRAWING NO. D4035 REV. A
MFG. APPR.		SHEET 1 OF 5
APPROVED		TITLE: BASKET LID RIB ASSY — SCALE: NTS
DE APPR.		
DATE	10.03.04	

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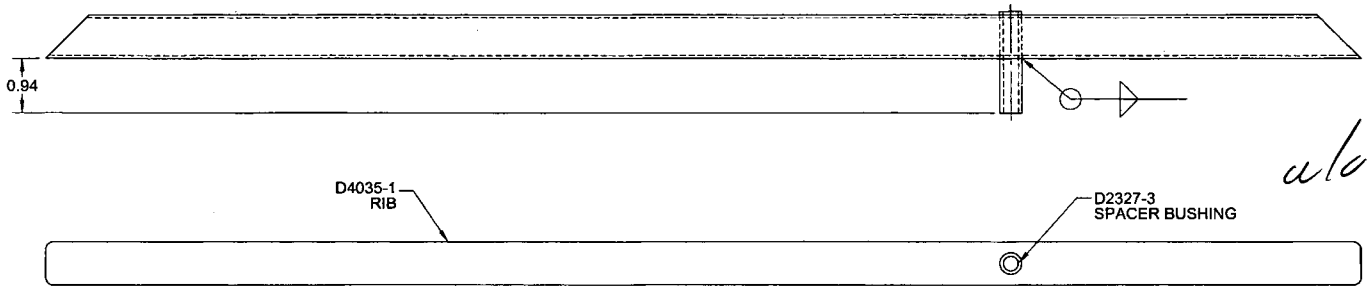
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

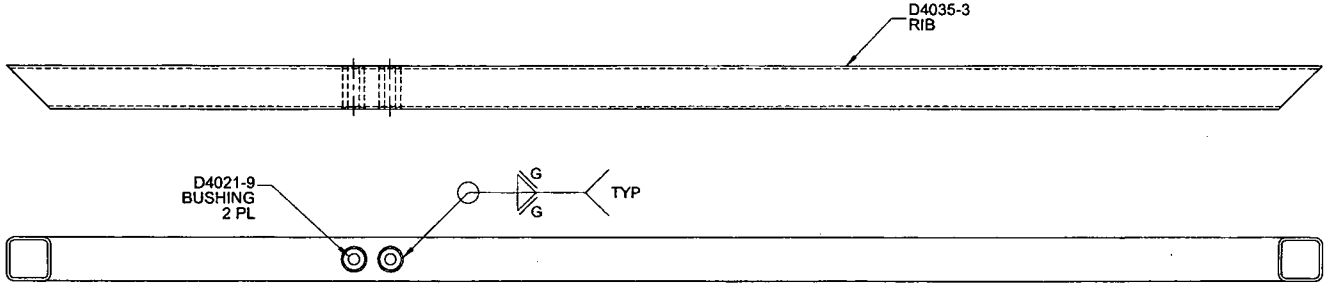
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



a/c 44431

D4035-041 BASKET LID RIB ASSY, FWD



D4035-043 BASKET LID RIB ASSY, AFT

RELEASED
2010 -03- 12

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.83 lbs
8) WELDING: PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	JPH	
CHECKED		DRAWING NO. D4035 REV. A
MFG. APPR.		SHEET 2 OF 5
APPROVED		TITLE BASKET LID RIB ASSY SCALE NTS
DE APPR.		
DATE	10.03.04	

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

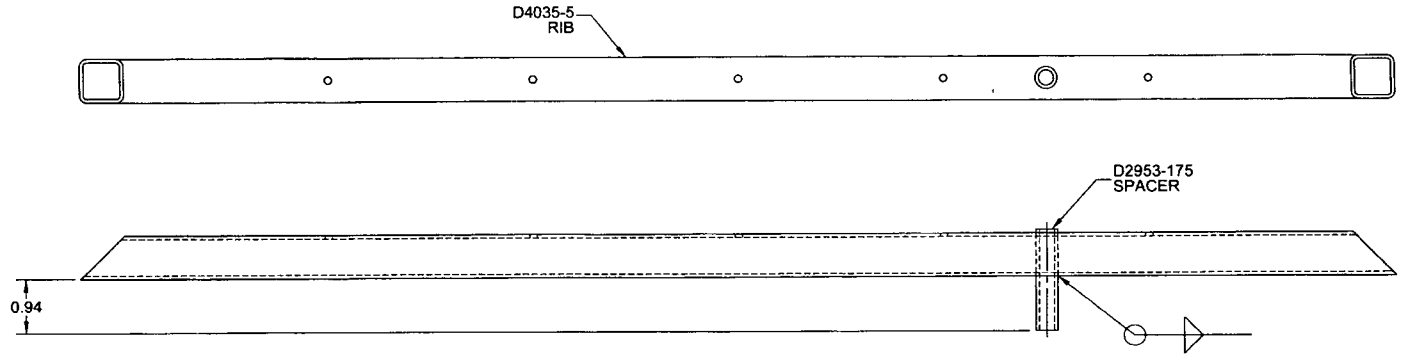
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

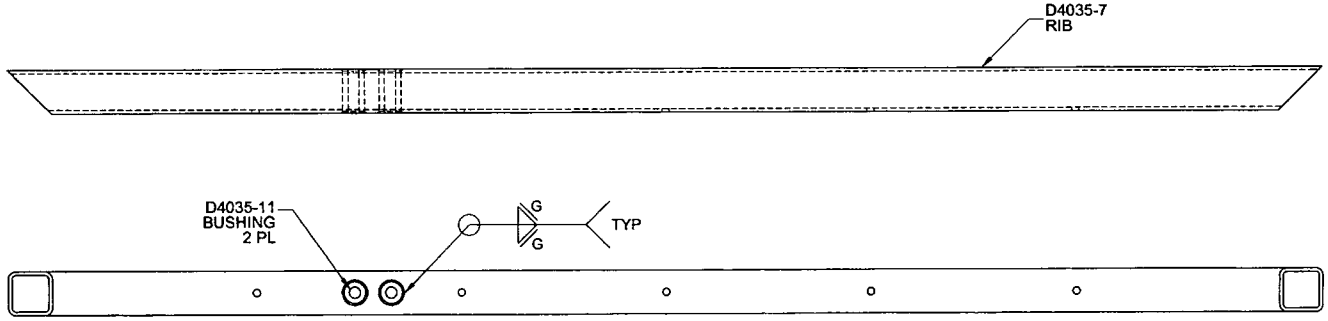
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

w/o 044137



D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)



D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

RELEASED
2010 -03- 12

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.34 lbs
8) WELDING: PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	JPH	
CHECKED		DRAWING NO. D4035 — REV. A — SHEET 3 OF 5
MFG. APPR.		
APPROVED		TITLE: BASKET LID RIB ASSY — SCALE: NTS
DE APPR.		
DATE	10.03.04	

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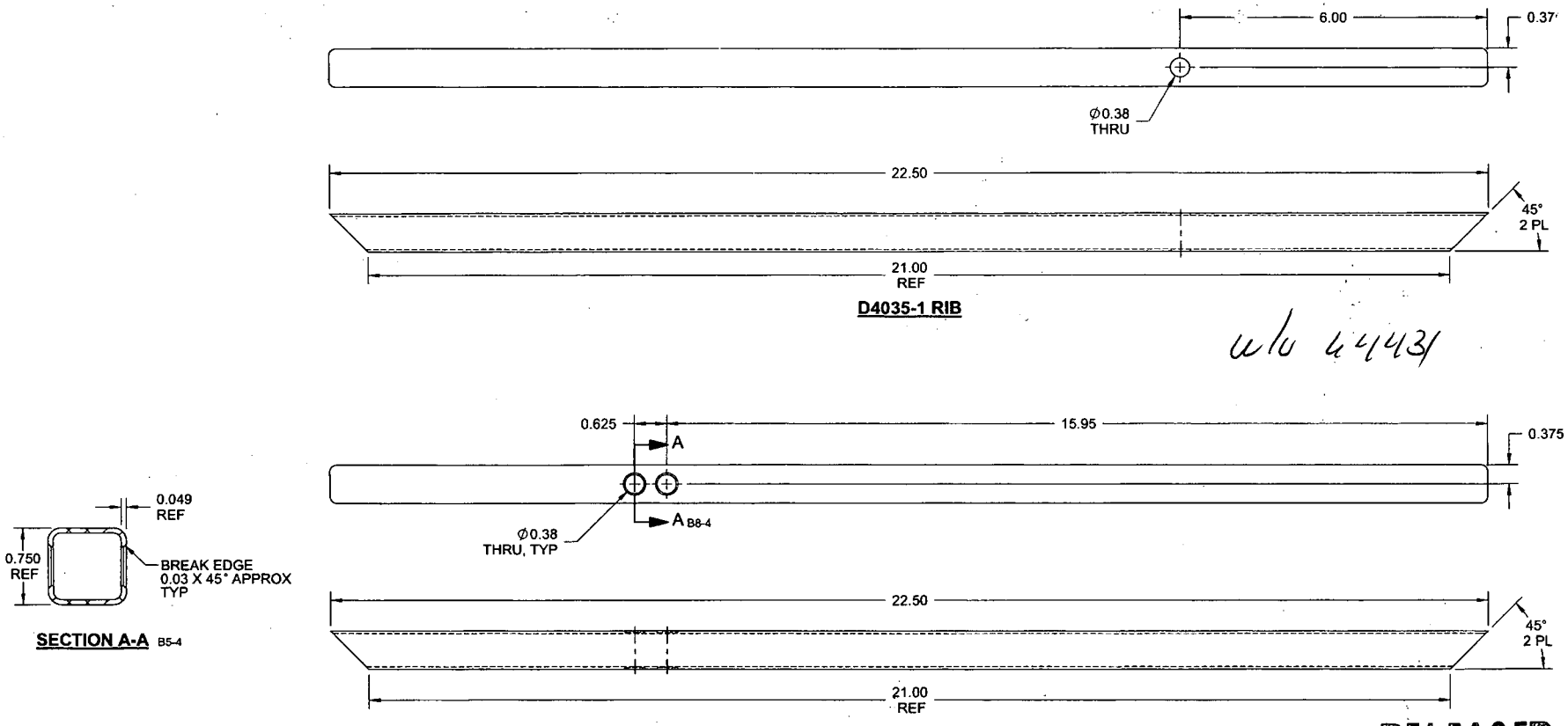
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



w/o 44431

SECTION A-A B5-4

RELEASED
2010 -03- 12

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
PER ASTM A554/A269 MILL FINISH
REF DART SPEC. M304TS0.750W.049
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.80 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	JPH	
CHECKED		DRAWING NO. D4035 REV. A
MFG. APPR.		SHEET 4 OF 5
APPROVED		TITLE BASKET LID RIB ASSY SCALE NTS
DE APPR.		
DATE	10.03.04	

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W/O:		WORK ORDER CHANGES					
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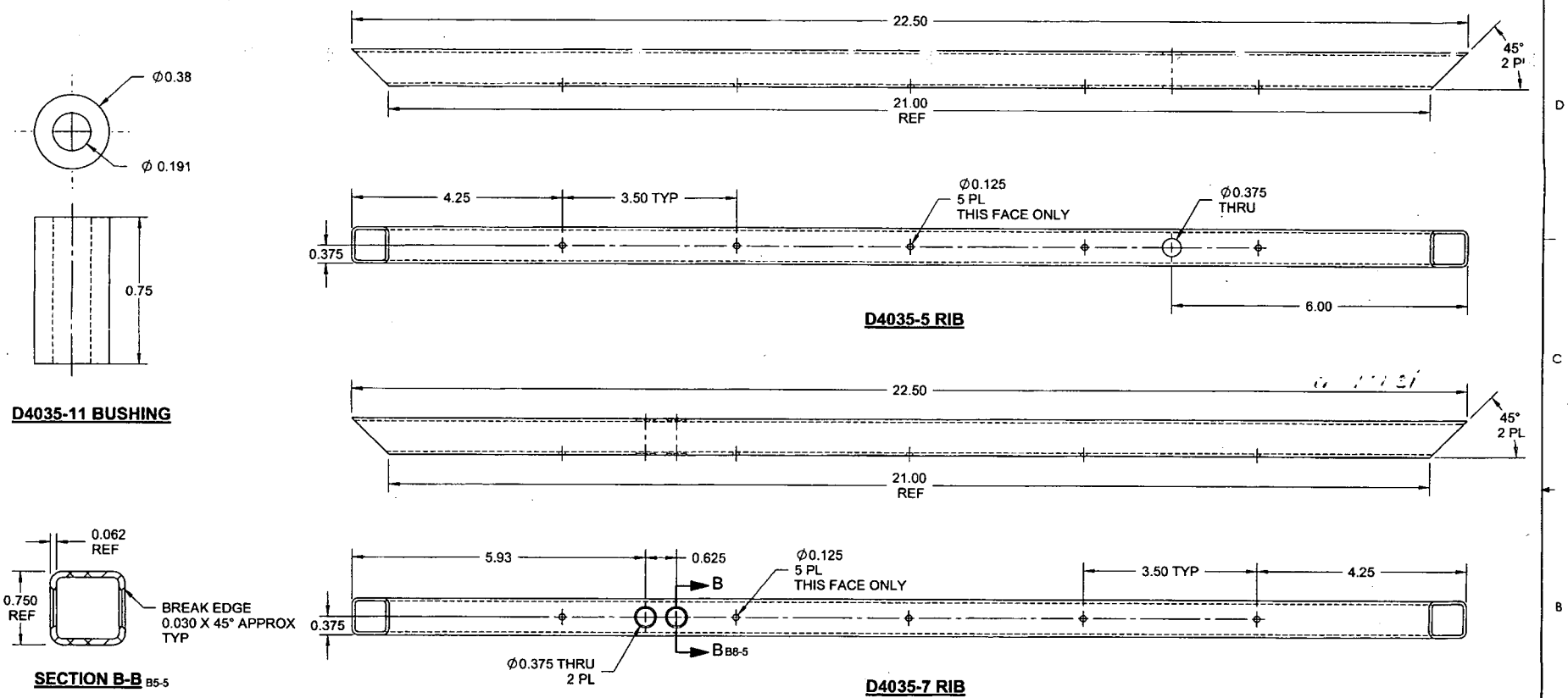
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

w/o 44431



RELEASED
2010 -03- 12

NOTES:
1) MATERIAL: -5 & -7: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC. M6061T6TS0.750W.062
-11: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC. M6061T6R
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: -5 & -7: 0.33 lbs; -11: 0.01 lbs

DESIGN	AJS	DART AEROSPACE LTD
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4035 REV. A
MFG. APPR.		SHEET 5 OF 5
APPROVED		TITLE BASKET LID RIB ASSY SCALE NTS
DE APPR.		
DATE	10.03.04	

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